

Date: Thursday, 2/9/2006 1:43:27 PM  
User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BASKET LID ASSEMBLY								
Job Number	: 25759A											
Estimate Number	: 10206											
P.O. Number	: N/A		Part Number	: D2989041								
This Issue	: 2/9/2006		S.O. No.	: N/A		Drawing Number	: D2989 REV B					
Prsht Rev.	: NC		Type	: LARGE FAB ASSY		Project Number	: N/A					
First Issue	: N/A					Drawing Revision	: B					
Previous Run	: 25757A					Material	: N/A					
Written By			<u>See Comment Below</u>		Due Date	: 2/7/2006			Qty:	1	Um:	Each
Checked & Approved By			<u>KJ 06.02.10</u>									
Comment			: Est Rev:I Removed D2989-043 05-11-03		JLM							

### Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D31663	Basket Hoop
		
		
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
	Pick:	
	Qty.(1) D3166-3 Batch: B25896	PD 06-03-03
2.0	D2581	Mounting Bracket
		
		
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
	Pick:	
	Qty Part number Description Batch	
	2 D2581 Mounting Brackets B25135	PD 06-03-03
3.0	D23273	Spacer Bushing
		
		
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
	Pick:	
	Qty Part number Description Batch	
	2 D2327-3 Bushing B24874	PD 06-03-03
4.0	D2506	Placard
		
		
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
	Pick:	
	Qty Part number Description Batch	
	1 D2506 Label Plate B24875	PD 06-03-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BASKET LID ASSEMBLY

Job Number: 25759A

Part Number: D2989041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 M304EX07516F Expanded Metal Flat Stai



Comment: Qty.: 15.0000 sf(s)/Unit Total : 15.0000 sf(s)

Pick:

Qty Part number Description Batch  
15sf M304EX0.75-16F Expanded Metal M100071

PD 06-03-03

6.0 M304TS0750W065 304 SQ Tube.75x.75x.065W



Comment: Qty.: 31.7709 f(s)/Unit Total : 31.7709 f(s)

3/4" x 3/4" x 0.063" wall 304/316 SStubing.

Batch: M100138 M100093 (30.025)

PD 06-03-03

7.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut (4) D2236-1 From D3166-3 As Per Dwg D2989

2-Drill holes in tubing as D2989-041 per Dwg D2989

3-Deburr and remove all markings on material

4-Weld as per Dwg D2989 and D2989-041 Assembly using Welding Table and corner Jig. Deburr as required

Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid

①

5-Drill Ø0.257" hole as D2989-041 per Dwg D2989 Identify as D2989-041

PD 06-03-03

8.0 QC9/6 DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

① 06/03/13 ①

9.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

① 06 03 14 ①

1-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

2-Wing walk D2989-041 as per Dwg D2989 and QSI 005 4.4

Spray Paint Black: M19640

Wing Walk: M10037

① 06 03 14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/03/17  
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D2989041

Job Number:



Seq. #: Machine Or Operation:

Description :

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



06-03-16 ①

Comment: Inspect Powder Coat and Wing Walk

11.0 DC

DOCUMENT CONTROL



① 06/03/17

Comment: DOCUMENT CONTROL  
Inspection Level 21

Job Completion



u 06-03-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN DS	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2989	REV. B SHEET 1 OF 3
DATE 05.06.07		TITLE BASKET LID ASSEMBLY	SCALE NTS
A	00.10.27	NEW ISSUE	
B	05.06.07	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	

RELEASED

05-08-19 *[Signature]*

PARTS LIST:

Qty -041	Qty -043	Part Number	Description
X		D2989-041	BASKET LID ASSEMBLY (OUTSIDE)
	X	D2989-043	BASKET LID ASSEMBLY (INSIDE)
1		D2989-1	STRUT
1		D2989-2	STRUT
1		D2989-3	STRUT
1		D2989-4	STRUT
2		D2989-5	STRUT
2		D2989-7	STRUT
1		D2989-9	STRUT
1		D2989-10	STRUT
1		D2989-11	STRUT
1		D2989-12	STRUT
2		D2989-13	STRUT
2		D2989-15	STRUT
2		D2327-3	SPACER BUSHING
1		D2506	LABEL PLATE
2	2	D2989-17	STRUT (96.00" LONG)
2		D2989-19	STRUT (31.19" LONG)
1		D2512-7	STRUT
2		D2581	MOUNTING BRACKET
	2	D3182-1	HINGE
	2	D3442-3	SHIM

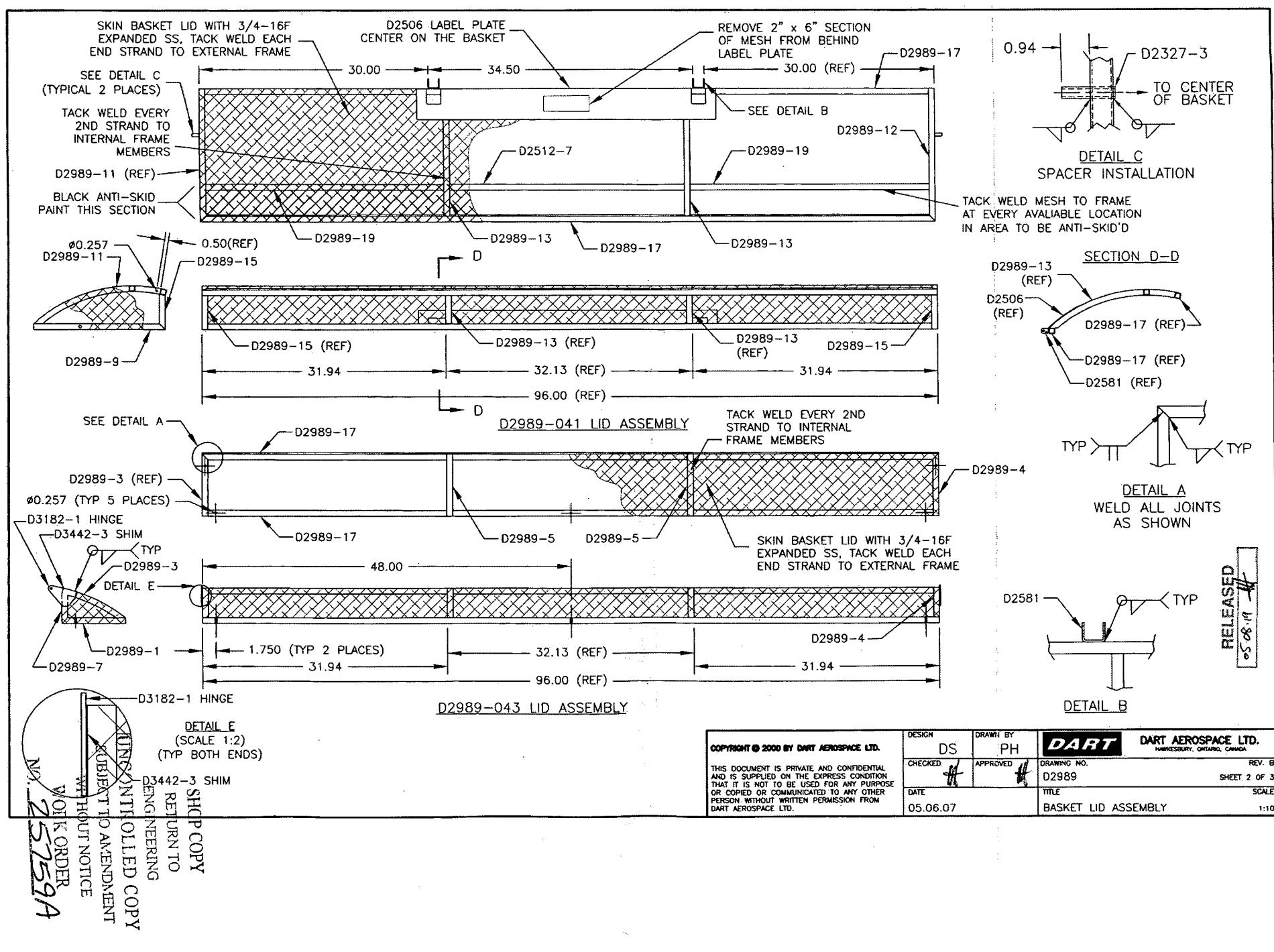
NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.060 WALL SQUARE TUBING  
D2989-3/4/5/11/12/13 CAN BE MADE FROM D2236
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)  
3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4.  
INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

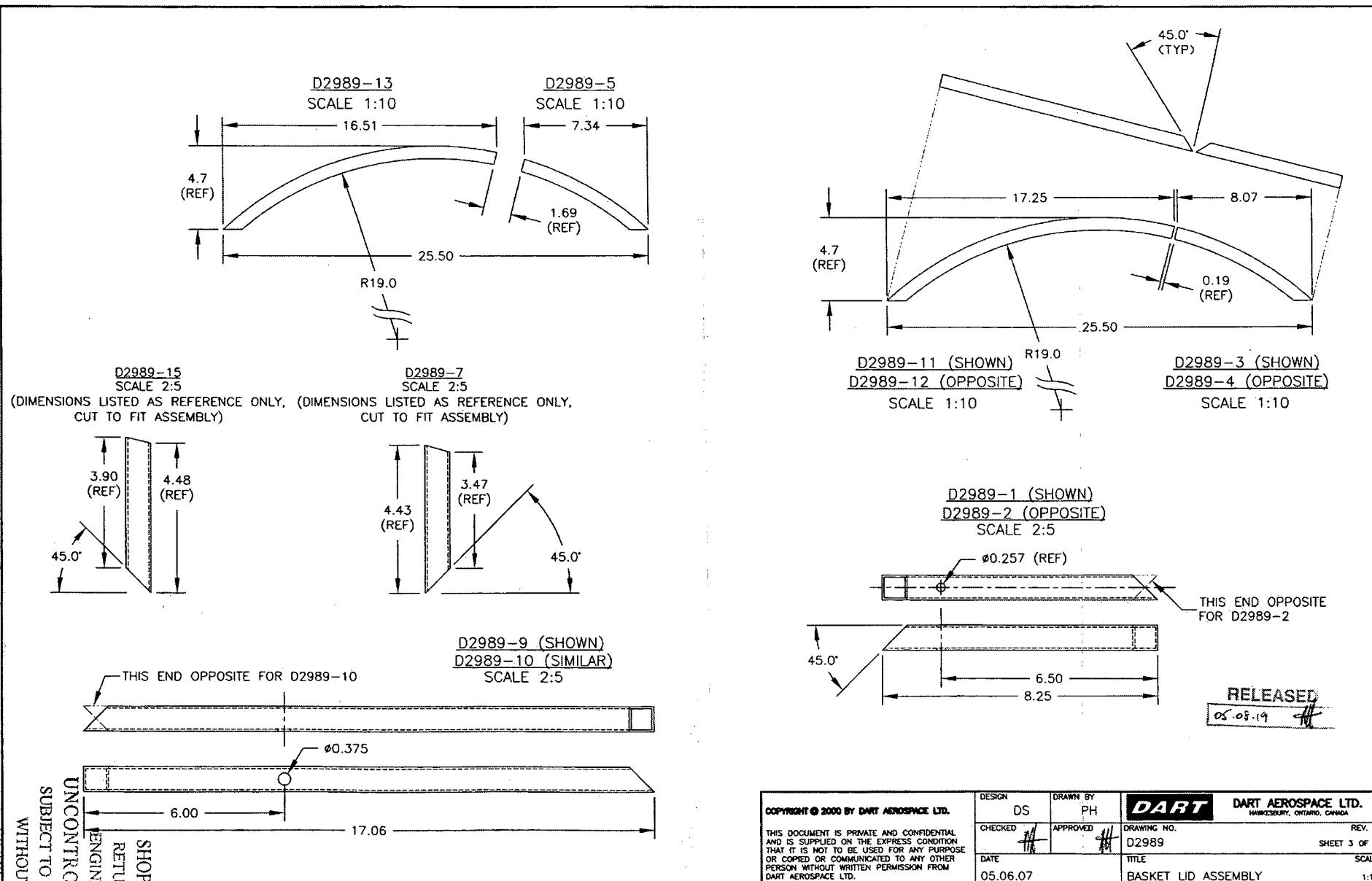
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DATE 05.06.07		TITLE BASKET LID ASSEMBLY		SCALE 1:10	